

# Work Order ID 69491

Wednesday, May 11, 2011 12:57:42 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*P*

Date: *11-05-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3914

B

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *117884* 0.00  
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

*PL 11.07.13*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

*11.07.13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	5/11/2011	Start Qty:	1.00			
Required Date:	5/13/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00							
130 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo	0.00							
	*** mask sides of hinge prior to powdercoat***								
	Start Time: 11:23								
	Oven Temperature: 300°								
	Finish Time: 11:55								
140 	Wing Walk as per dwg QSI005 4.4 Batch AL 11 7863								
HandFinish Hand Finishing	Memo	0.00							
	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								
	2- Install placard and label as per dwg								
	***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PS 11/07/15 @

160

Identify as per dwg &amp; Stock Location GA

0.00



Packaging

Memo

0.00

Packaging

w/o  
69486

PS 11/07/15 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/18 J  
MF  
11-07-15

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# Picklist Print

Wednesday, May 11, 2011 12:57:51 PM

Page 1

Work Order ID: 69491

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>38</div> <div>707 66</div> </div>													
<div> <div>68964</div> <div>38</div> <div></div> </div>													
D3914-1  Rib		Manufactured	No			100	Each	2.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div>B69520</div> </div>													
<div> <div>69087</div> <div>2</div> <div></div> </div>													
D3914-7  Rib		Manufactured	No			100	Each	8.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>4</div> <div>70335</div> </div>													
<div> <div>69277</div> <div>4</div> <div></div> </div>													
<div> <div>WA006</div> <div>4</div> <div></div> </div>													
<div> <div>68175</div> <div>4</div> <div></div> </div>													

SAD 11-07-08  
  
 SAD 11-07-08  
  
 SAD 11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 69491

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3  
Hinge Half, Lid

Manufactured No

100 Each

9.0000 3 3



SAO 11-07-08

Location

Loc Qty

Loc Code

ST109

6

B69164

③

68512

6

WA005

3

67040

3

D4018-5  
Rib

Manufactured No

100 Each

37.0000 9 9



SAO 11-07-08

Location

Loc Qty

Loc Code

WA005

37

B69163

⑨

67041

14

69013

23

D4020-5  
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

2.0000 1 1



Pld 11-07-13

Location

Loc Qty

Loc Code

WA

2

B70235 → ①

68234

2

D4021-3  
Data Plate

Manufactured No

100 Each

3.0000 1 1



SAO 11-07-08

Location

Loc Qty

Loc Code

WA005

3

B70240

①

66721

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 69491

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100 Each

4.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

Location

WA006

67374

Loc Qty

4

4

Loc Code

B69727

6.0000

1

1



SAD 11-07-08

D4035-043

Manufactured No

100 Each



Lid Rib Assembly, Aft (350 Basket)

Location

WA006

67375

Loc Qty

6

6

Loc Code

B69869

0.0000

1

1



SAD 11-07-08

D2728-3

Manufactured No

140 Each



Dart Logo label



M115050 11/7/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

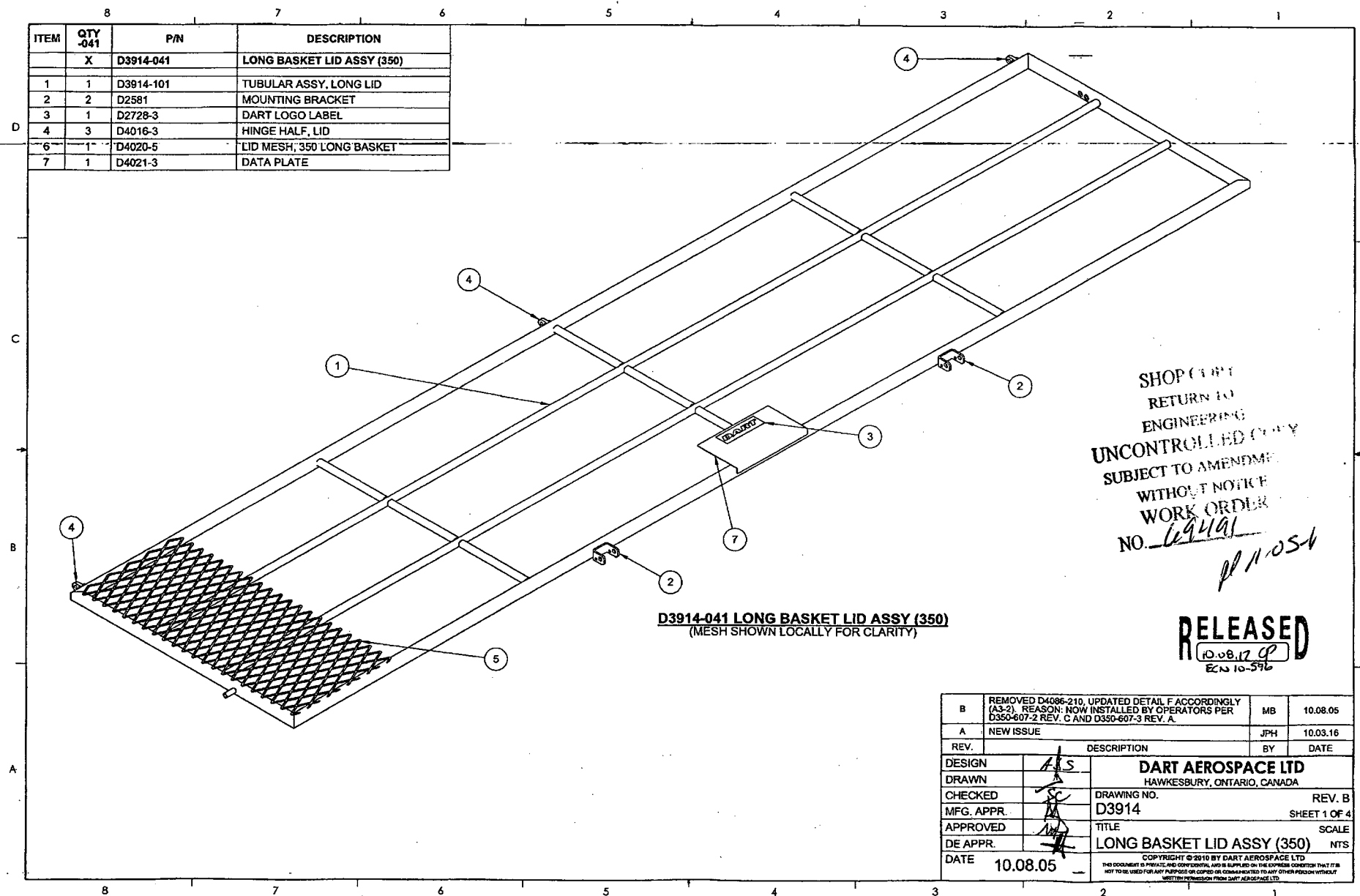
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69491  
PP 11-054

**RELEASED**  
10-08-17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC	SHEET 1 OF 4	
MFG. APPR.	ALS	TITLE	SCALE
APPROVED	ALS	LONG BASKET LID ASSY (350) NTS	
DE APPR.	ALS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

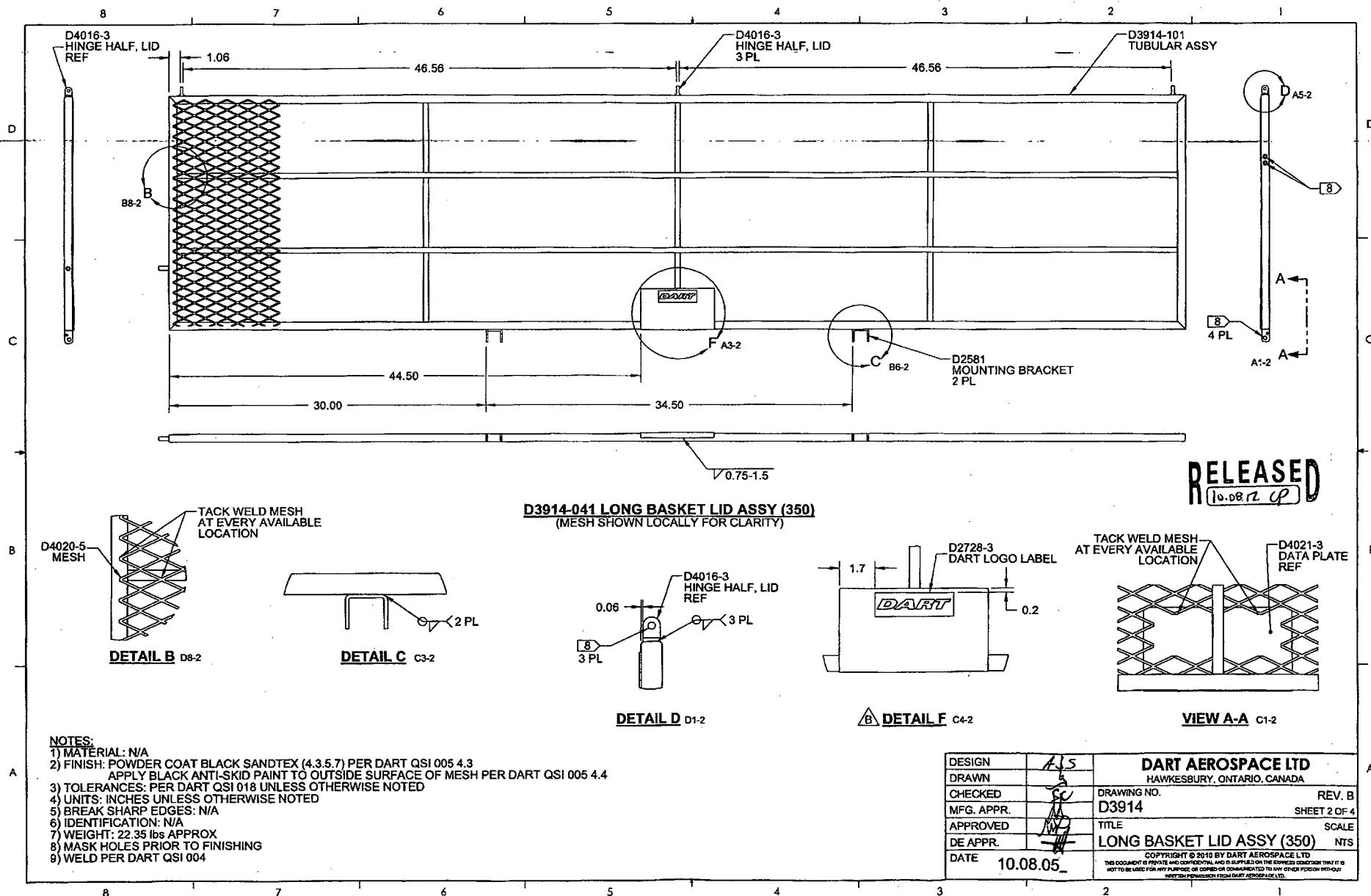
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

who 69491



W/O:		WORK ORDER CHANGES					
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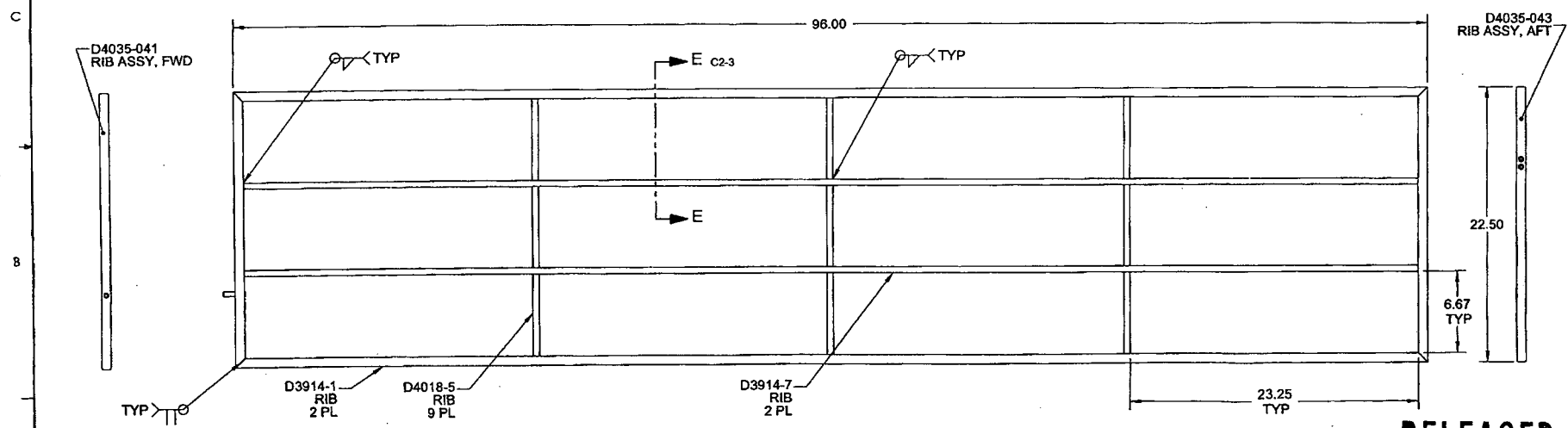
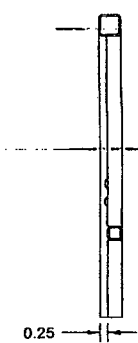
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WLO 0949

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID

**RELEASED**  
10-28-12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.10 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
  - 9) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC	DRAWING NO. <b>D3914</b>	REV. B
CHECKED	WJ	SHEET 3 OF 4	
MFG. APPR.		TITLE <b>LONG BASKET LID ASSY (350)</b>	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.		DATE <b>10.08.05</b>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

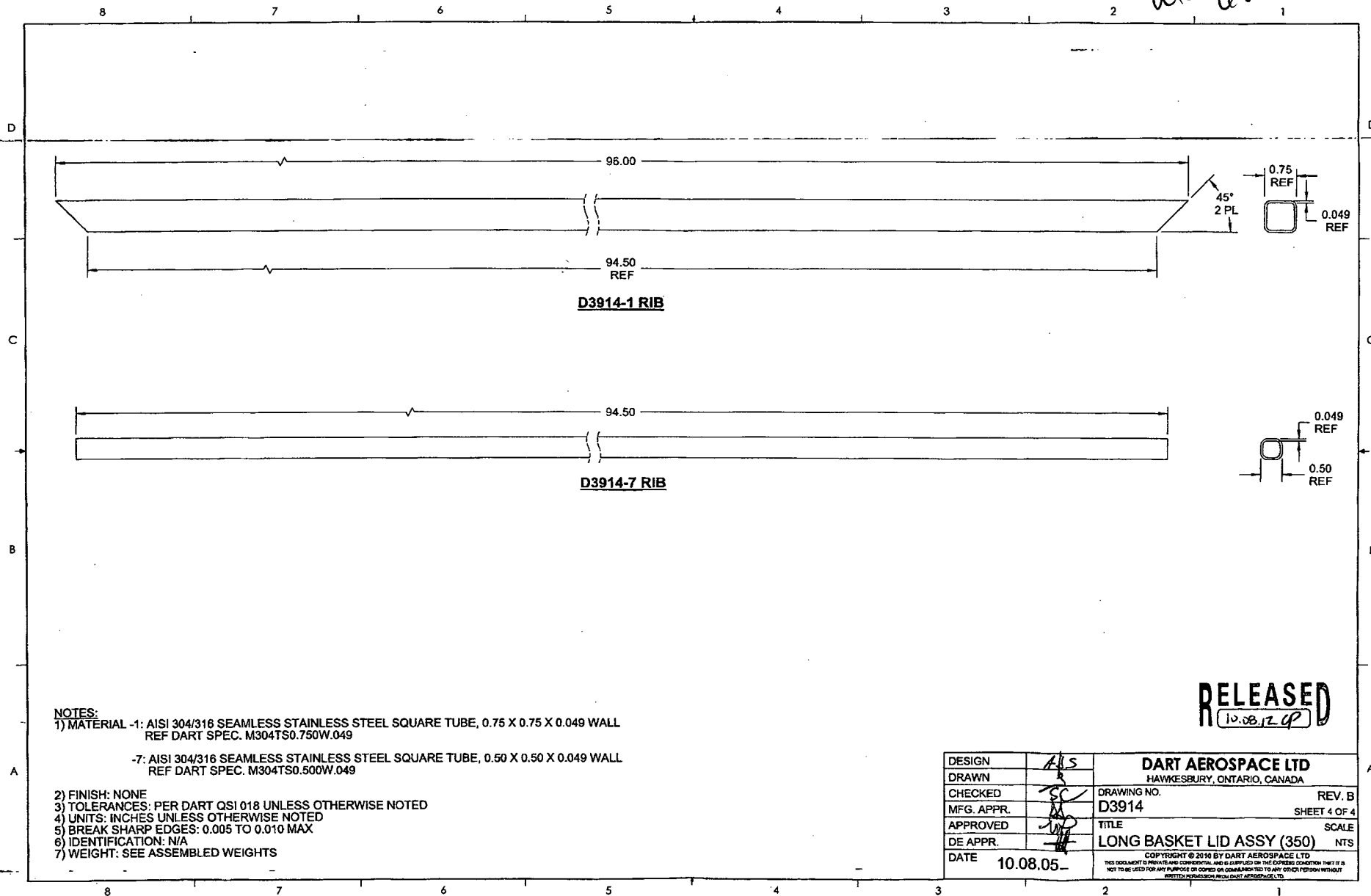
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alo (1999)



NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED  
10.08.12 LP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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